

APR 23 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DSI 9775-011

Job Sheet 176334



Part No: DSI 9775-011

Job Qty: 1 ea

Part Name: Skidtube Doubler Installation



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/20/18

Job Tracking No:

Due Date: 5/25/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev. A New issue JFS 17/04/05 Verified by: DD

Ship Via:

DAS
21
9-89DAS
10
9-89

chgoen

See attachment

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/25/18	0.00	0.00	Start Up Stores/Pkg-1		MAY 01 2018
110	Packaging	1 pcs		5/25/18	0.00	0.00	Packaging1-5		MAY 01 2018
120	QC	1 pcs		5/25/18	0.00	0.00	QC4		J.R.B. 28
125	DC	1 pcs		5/25/18	0.00	0.00	DC		J.R.B. 9-89
130	Packaging	1 pcs		5/25/18	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea		5/25/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3524-5-3	Rivet, Countersunk	160 Ea (160 ea)	90-Start up Operation	5035966
D5514-1	Doubler	4 Ea (4 ea)	90-Start up Operation	5063620
D5517-1	Ground Handling Pin	4 Ea (4 ea)	90-Start up Operation	5075072

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CR3524-5-3	160	420	0
	D5514-1	4	0	0
	D5517-1	4	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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CANADA
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Plex 4/20/18 12:52 PM Dart.lajeunesse.marie

Container No: S077002



Part: DSI 9775-011

Job No: 176334

Serial No/Batch: S077002

Revision:

Inspector:

Exp Date: 06/01/2018

Instructions:

Date: 06/01/18

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

2.9 Apply a 0.010" (0.3mm) thick layer of Proseal 890 B1/2 or Proseal 1422 B1/2 to the inner surface of one doubler.

REFERENCE ONLY

2.10 Using cleco clamps, secure the doubler onto one side of the skidtube.

2.11 Liberally coat the shoulder on one end of each pin with Proseal 890 B1/2 or Proseal 1422 B1/2 and insert that end through the skidtube into the doubler.

2.12 Liberally coat the shoulder on the other end of the pins with Proseal 890 B1/2 or Proseal 1422 B1/2.

2.13 Apply a 0.010" (0.3mm) thick layer of Proseal 890 B1/2 or Proseal 1422 B1/2 to the inner surface of the second doubler.

2.14 Using cleco clamps, secure the second doubler onto the other side of the skidtube.

2.15 Ensure that both doublers are flush against the surface of the skidtube.

2.16 Ensure that the doublers and pins remain properly aligned per Figure 2 of this service instruction.

2.17 Using CR3524-5-3 Rivets, secure both doublers to the skidtube. Reference Figure 3 of this service instruction

2.18 Remove all excess Proseal.

2.19 Relocate the float hose support brackets if necessary.

2.20 Reinstall the modified skidtube onto the aircraft per ICA-D117-762 Chapter 32.2 / 32.8 / 32.10.

2.21 Repeat steps 2.1 thru 2.20 on the other skidtube.

2.22 Update the aircraft log book as applicable to indicate installation of the DSI 9775-011 Skidtube Doubler Kit.

3.0 PARTS LIST

The DSI 9775-011 Skidtube Doubler Kit contains the parts required to modify Qty (2) skidtubes.

*Qty (8) additional rivets are provided with the kit.

Qty -011	Part Number	Description
X	DSI 9775-011	SKIDTUBE DOUBLER
4	D5514-1	DOUBLER
4	D5517-1	GROUND HANDLING PIN
*160	CR3524-5-3	RIVET, COUNTERSUNK

4.0 WEIGHT AND BALANCE

When the DSI 9775-011 Skidtube Doubler Kit is installed on both skidtubes, there is a net weight increase as stated in the following table.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9775-011 SKIDTUBE DOUBLER KIT	2.2 lb 1.0 kg	0 in 0 m	0 in-lb 0 m-kg	180 in 4.6 m	396 in-lb 4.6 m-kg

REFERENCE ONLY

APPROVED

DESIGN	ML	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	NO	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9775	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SKIDTUBE DOUBLER	NTS
DATE	17.03.21	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Change Record

PAGE 1 OF 1

Part Number: DSI 9775-011

Description: SKIDTUBE DOUBLER INSTALLATION

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									